

[illegible]

February 12, 2010 9:54:05 AM

[illegible]

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Journal of Internal Medicine 247: 111–116

...the ...

[illegible]

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Journal of Internal Medicine 247: 111–118

10.22.12.

[illegible][illegible]

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D2803	Rev B

**THE UNIVERSITY OF CHICAGO**

0.00

## Memo

☐ Dwg Rev: \_\_\_\_\_ ☐ Prog Rev: \_\_\_\_\_ ☐ 2-

[illegible]

0.00

## Memo

Machine as per folio FA102

0.00

\_\_\_\_\_

## Memo

## Quality Control

# Work Order ID 56187

February 12, 2010 9:54:05 AM



Page 2

Item ID:	D2803-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket					
Start Date:	12/02/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	25/02/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>Dr 10/02/17</i>		<u>2</u>	<u>0</u>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo  <i>QC3-</i>	0.00  0.00		<i>Dr 10-02-17</i>  <i>HL 10/02/18</i>		<i>(2) p</i>  <i>(X2) p</i>			
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>147</u>  Memo	0.00  0.00							<i>10/2/18</i>

**Work Order ID 56187**

February 12, 2010 9:54:05 AM



Page 3

Item ID: D2803-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/02/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 25/02/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18 *[Signature]*  
*MUE*  
10-2-18

# Picklist Print

February 12, 2010 9:54:05 AM

Page 1  
1

Work Order ID: 56187



Parent Item: D2803-2



Parent Item Name: Bracket

Start Date: 12/02/2010

Required Date: 25/02/2010

Comments: IPP A 00.11.06 New Issue EC  
IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM  
IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	47.3000	4.0352			



1810-2-12

6061-T6 Bar .500 x 10.00

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
MAT	47.3	
109288	0.3	
111382	23	
112764	24	

112764

DART AEROSPACE LTD		Work Order:	56187
Description: Bracket		Part Number:	D2803-2
Inspection Dwg: D2803 Rev: B		Page 1 of 1	

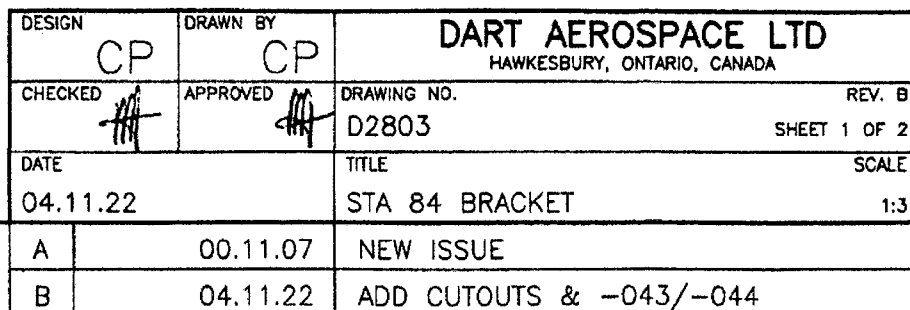
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

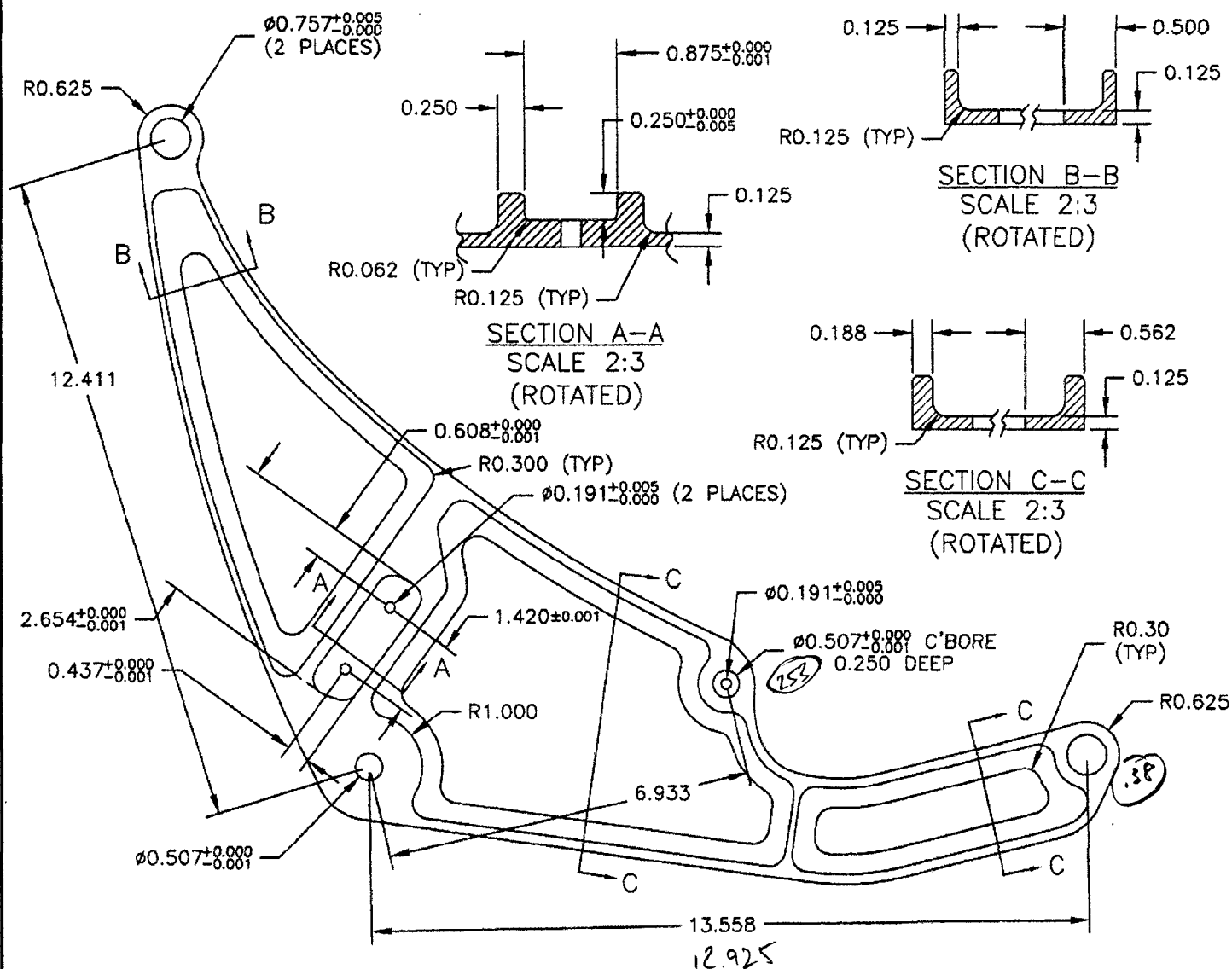
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.760	/			
1.420	+/-0.001	1.420	/			
Ø0.191	+0.005/-0.000	.196	/			
Ø0.507	+0.000/-0.001	.5065	/			
Ø0.507 x 0.250	+0.000/-0.001	.5065 x .247	/			
12.411	+/-0.010	12.411	/			
6.933	+/-0.010	6.933	/			
0.250	+/-0.010	.250	/			
0.875	+0.000/-0.001	.8745	/			
0.250	+0.000/-0.005	.247	/			
0.125	+/-0.010	.125	/			
0.125	+/-0.010	.125	/			
0.500	+/-0.010	.500	/			
0.125	+/-0.010	.125	/			
0.188	+/-0.010	.188	/			
0.562	+/-0.010	.563	/			
0.125	+/-0.010	.125	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10.2.17	Date: 10/02/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	<i>[Signature]</i>



05.03 11 ~~11~~



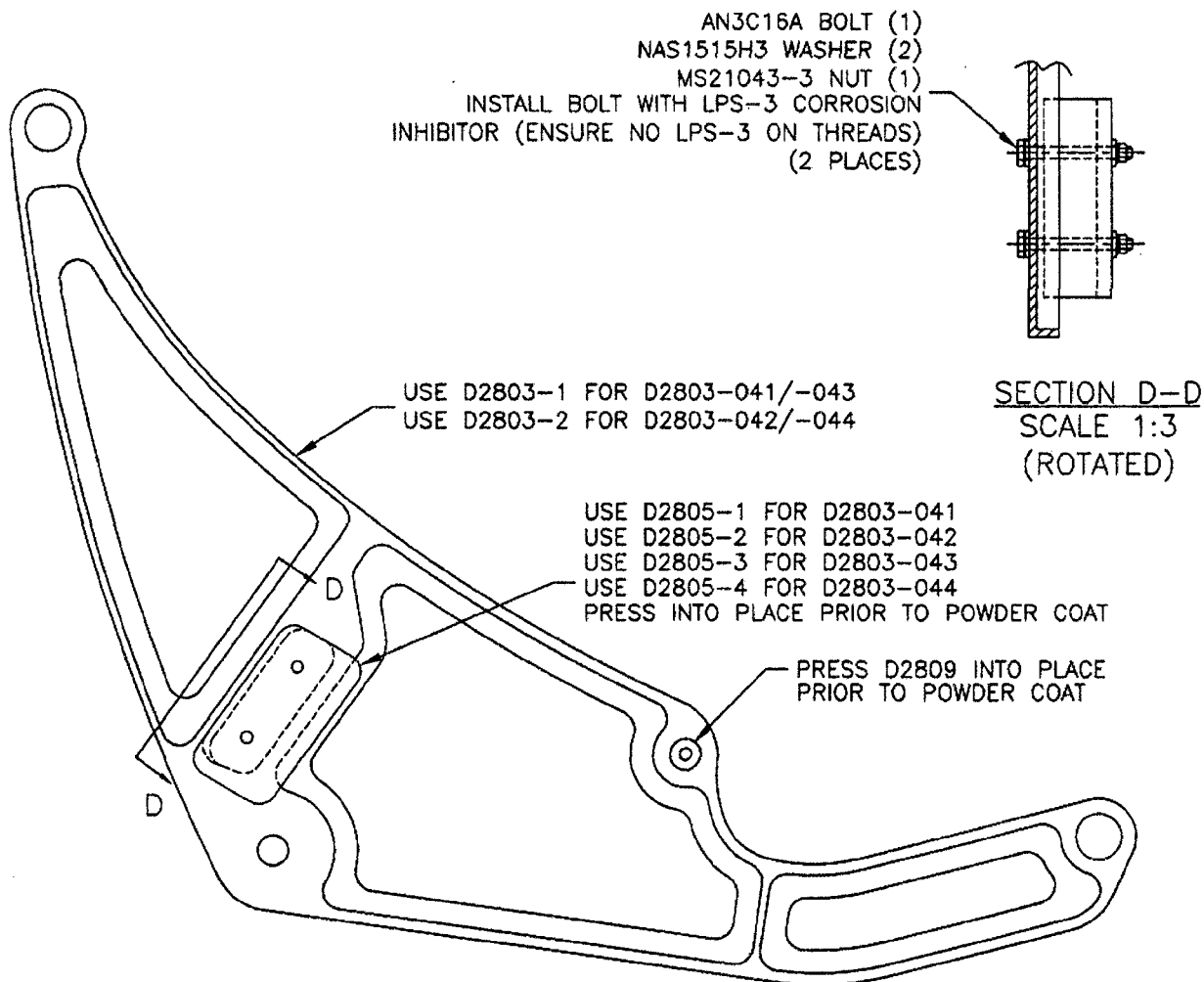
2018

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"  
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK  
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



52187

RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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